Each

Dart Aerospace Ltd. Wednesday, 12/20/2006 1:47:30 PM User: Kim Johnston **Process Sheet** : SADDLE SPACER : CU-DAR001 Dart Helicopters Services **Drawing Name** Customer Job Number : 30055 : 10827 **Estimate Number** : D2877 : NIA **Part Number** P.O. Number S.O. No. : MA : D2877 REV B **Drawing Number** : 12/20/2006 This Issue : N/A Project Number Prsht Rev. : SMALL /MED FAB **Drawing Revision** Type First Issue : 28481 Material **Previous Run** : 1/2/2007 120 Um: Qty: **Due Date** Written By Checked & Approved By 00.05.19 Added inspect level 8 EC В Comment : Est С 06.04.26 Water jet EC Est 06-06-23 JLM Now M6061-T6 Est Rev:D Updated Thickness as per Rev B 06-09-18 JLM Est Rev:E **Additional Product** Job Number: Description: Machine Or Operation: Seq. #: 6061-T6 .125 Sheet 1.0 M6061T6S125 65.6208 sf(s) Comment: Qty.: 0.5468 sf(s)/Unit Total: Material: 6061-T6 (QQ-A-250/8) 0.125" Thick Batch: 10103 2.0 WATER JET Comment: FLOW WATER JET 1-Cut as per Dwg D2877 Dwg Rev: 15 07/01/03 Prog Rev: 5 2- Tumble INSPECT PARTS AS THEY COME OFF MACHINE QC2 3.0 PARTS AS THEY COME OFF MACHINE Comment: INSPECT



4.0 QC8 SECOND CHECK

Comment: SECOND CHECK SMALL FAB 1 5.0



SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble

Deburr any rough edges after tumbling







- 01-07



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W/O: WOI				WORK ORDER CHANGES								
DATE	STEP		PROCEDURE	CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date: 07/01/18
			QA: N/C Closed:	Date:

NCR:			WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B		Verification	Approval	Annroyal				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector				
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NOTE: Date & initial all entries

Wednesday, 12/20/2006 1:47:30 PM Date: **Process Sheet** User: Kim Johnston **Drawing Name: SADDLE SPACER** Customer: CU-DAR001 Dart Helicopters Services Job Number: 30055 Part Number: D2877 Job Number: Seq. #: Description: Machine Or Operation: HAND FINISHING RESOURCE #1 6.0 HAND FINISHING1 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 INSPECT POWDER COAT/CHEMICAL CONVERSION 7.0 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION PACKAGING RESOURCE #1 8.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 9.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE 15 Job Completion

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W/O:		WORK ORDER CHANGES	3					
DATE	STEP	PROCEDURE CHANGE	В	У	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #: Fault Category: N	NCR: Y	es/	No DQA	. :	Date: _	
			Q	A:	N/C Closed	:	Date: _	

NCR:		,	WORK ORE	DER NON-CONFORMANO	E (NCR)			
		Description of NC		Corrective Action Section B	Verification	Ammanat	A	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order: DART AEROSPACE LTD Part Number: D2877 Description: Saddle Spacer

Inspection Dwg	: D2877 Rev	: B				Pa	ge 1 of 1
	FIRS	T ARTICLE IN	NSPECTI	ON CHI	ECKLIST		
	X	First Arti	cle	Prot	otype		
Drawing	Tolerance	Actual	Accept	Reject	Method of Inspection	Cor	nments
Dimension		Dimension			mapeonon	ļ	
0.98	+/-0.030	0.989	/		vern	-	
R0.06	+/-0.030	RO.06			RADIUSG	unge	
R0.30	+/-0.030	RO.30	.V		RAdius 6	UM	
1.00	+/-0.030	1.00	1		Vern	0	
0.250	+0.030/-0.000	0.250	1.		verN		
Ø0.257	+0.005/-0.000	0.257	\checkmark		VecN		
0:100 thick	+/-0.005	0.124	J		vern		
0.125"							
per Du	ち						
E							
			,				
<u> </u>							
Measured by:	ml.ml	Audited by:	717		Prototype A		N/A
Date:	27/01/03	Date:	07/01	104		Date:	N/A
Rev Date	Change					Revised by	Approved
A 04.01.21	New Issue				K	J/RF	1

Rev	Date	Change	Revised by	Approved
Α	04.01.21	New Issue	KJ/RF	1
В	06.06.23	Dwg Rev. changed	KJ/JLM KJ	



DRAWN BY DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA REV. B APPROVED A DRAWING NO. CHECKED D2877 SHEET 1 OF 1 SCALE DATE SADDLE SPACER 06.05.17 1:1 99.02.23 **NEW ISSUE** THICKNESS WAS 0.100", MAT CHANGE

RELEASED

RO.44 (TYP 2 PLACES) 0.98 -R0.06 (TYP. 4 PLACES) Ø0.257 (TYP) 3.36 2.358 R0.30 R0.88 (TYP) 1.00 1.179 R0.40 (TYP) 0.555 -0.542 -0.250±0.030 (TYP)

06.05.17

В

1) MATERIAL: 6061-T6 ALUMINUM SHEET (QQ-A-250/11) 0.125" THICK (REF DART SPEC M6061T6S.125)

NOTES:

5052-H32/H34 ALUMINUM SHEET (QQ-A-250/8) 0.125" THICK CONTROLLED COPY

1.370

- 2.36 ·

(REF DART SPEC M5052H32S.125)

2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) BREAK ALL SHARP EDGES 0.010 TO 0.020

5) ALL DIMENSIONS ARE IN INCHES

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ENGINEERING

SUBJECT TO AMENDMENT

WITHOUT NOTICE WORK ORDER